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D4297-1
Job Sheet 186883



Part No: D4297-1

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 11-01-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	4 pcs	12/12/18	12/12/18	0.00	0.93	Waterjet - Flow		<i>52</i> <i>17/01/18</i>
130	CNC Vertical Machining	4 pcs	12/12/18	12/12/18	0.00	5.90	HAAS1-4		<i>52</i> <i>17/01/18</i>
140	QC	4 pcs	12/12/18	12/12/18	0.00	0.00	QC2 Machining-2		<i>52</i> <i>17/01/18</i>
150	QC	4 pcs	12/12/18	12/12/18	0.00	0.00	QC8 Machining-2		<i>52</i> <i>17/01/18</i>
151	Packaging	4 pcs	12/12/18	12/12/18	0.00	0.00	Packaging3		<i>52</i> <i>17/01/18</i>
190	QC21-SA	4 Ea	12/12/18	12/12/18	0.00	0.00	QC21		<i>52</i> <i>17/01/18</i>

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA028 and Dwg DWG

REV: _____ FOLIO REV: _____ 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	14.8000 sf (3.7 ea)	120-Waterjet - Flow - 1	<i>5045598</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	15	426	0

Part Specifications

Specifications could not be found.

Plex 11/22/18 11:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order: 186883
Description: Bearpaw		Part Number: D4297-1
Inspection Dwg: D4297 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063 x 45°	V		Ver	
D 0.25 x 45°	+/-0.030	0.25 x 45°	V		Ver	
E R0.250	+/-0.030	R0.25	V		R.G.	
G 0.63	+/-0.030	0.64	V		Ver	
H 0.38	+0.030/-0.010	0.390	V		Ver	
I 0.950	+/-0.030	0.970	V		Ver	
J 19.000	+/-0.030	19.000	V		TAPE	
M Ø0.260	+0.005/-0.000	Ø0.260	V		G.P.	
N Ø0.93	+/-0.030	Ø0.931	V		Ver	
O 0.30	+0.030/-0.000	0.31	V		D.G.	
P 23.750	+/-0.030	23.750	V		TAPE	
S 2.000	+/-0.030	2.000	V		Ver	
T 0.20	+/-0.030	0.200	V		D.G.	
U 11.000	+/-0.010	11.000	V		TAPE	

Measured by: DAS 52	Audited by: [Signature]	Preliminary Approval:
Date: 9-89 19/01/25	Date: 19-01-14	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue P/O D350-578-013	KJ	
B	12.02.01	Dwg Rev updated	KJ	
C	12.07.31	Dwg Rev updated	KJ	
D	15.02.09	Dimensions revised	KJ	[Signature]



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Container No: S132067



Part: D4297 - 1

Job No: 186883

Serial No/Batch: S132067

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/18